Work Orde Wednesday, Febr													Page 1
Revision ID: Item Name: Start Date:	D3201-1 Doubler 3/2/2011	Start Qty: 12.00			Accept	Cust Item I				Setup	Start Stop		
Required Date: Reference:	3/4/2011	Req'd Qty: 12.00	1			Customer:							
Approvals:	Process Pla	in:	Date:	1-02-23	Tooling: SPC (Y/N):		nte:]	Run	Start Stop		
Sequence ID/ Work Center ID)	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr D3201	Rev Rev	ision Nbr B										1-1	
Waterjet FLOW CNC Waterje	t	FLOW WATER JET Memo 1-Cut as po Deburr if r	er Dwg D3201 necessary	□Dwg Rev:_	0.00 0.00 & □Prog Rev:	₿ □2-			N31	i-9.	- 38	(F)	
QC Quality Control		QC2- Inspect parts off Memo	machine FAI/F	AIB	0.00				Bi	<u>- 6</u> -	<u>8</u>		
120 		QC8- Inspect parts - se	cond check		0.00 5(1	162/25			(Y/))			

Memo

Quality Control

Dart Aerospace	Lt	:d
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W/O:	•		W	ORK ORDER CHAN	GES					•
DATE	STEP	PRO	DCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Ca	tegory:	NCR:	Yes N	lo DQ .	A :	_ Date: _	
	Re	esolution:	Disposit	ion:	QA: I	VC Clo	sed:		Date: _	
NCR:			WORK OR	DER NON-CONFORM	MANCE	(NCR)				
DATE	STEP	Description of NC			ection B	Sign &		cation	Approval	Approval
<i>D</i> , (; L	0121	Section A	Initial Chief Eng	Action Description Chief Eng	n	Date	Sect	ion C	Chief Eng	QC Inspector
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Work Order ID 66678

Wednesday, February 23, 2011 3:26:59 PM



Page 2

Item ID:

D3201-1

Accept

Setup Start

Revision ID:

Start Date:

Item Name:

Required Date: 3/4/2011

Doubler

3/2/2011

Start Qty: 12.00

Req'd Oty: 12.00



Date:_____

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

QC:

Tooling: Date:

SPC (Y/N):

Date:

Date:

Tool# Plan

Code

Run

Reject

Qty

Accept

Qty

Start Stop

Stop



Insp.

Stamp

Reject

Number

Sequence ID/ **Work Center ID**

130

Small Fab

Small Fab

Operation Description

Small Fab

Memo

Deburr Stack

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours**

0.00

140

HandFinish

Hand Finishing

Memo

0.00

=7 m / 11/02/28

12. Al 11-2-28.

150

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

QC

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Dart Aerospace Ltd

Dail Ac	ospace	Liu							
W/O:			W	ORK ORDER CHANG	ES				τ_
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQ	A:	Date: _	
	Re	esolution:	Dispositi	on:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK OR	DER NON-CONFORM	ANCE (NCF	₹)	, , , , ,		
DATE	STEP	Description of NC Section A	Initial	Action Description	ion B Sign &	& Secti	cation ion C	Approval Chief Eng	Approval QC Inspector
		Collon	Chief Eng	Chief Eng	Date	0001		Simol Ling	
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Page 3

Wednesday, February 23, 2011 3:26:59 PM

Item ID:

D3201-1

Accept



Setup Start

Stop



Revision ID:

Item Name:

Doubler

Start Date: 3/2/2011 Required Date: 3/4/2011 **Start Oty: 12.00**

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

A	nn	ro	va	s:

Process Plan:

Date:

Tooling:

Date:

Start

Stop

QC:

Date:_____

SPC (Y/N):

Date:

Run

Sequence ID/ **Work Center ID**

160

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

QC21- Final Inspection - Work Order Release

0.00

170

Memo

Memo

0.00

Quality Control

Dart A	eros	pace	Ltd
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W/O:			W	ORK ORDER CHANGI	ES		.,		<u>(***</u> .
DATE	STEP	PROC	EDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:							
	R	esolution:	_ Disposit	ion:	_ QA: N/C CI	osed:		Date: _	
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NCF	R)	i.		
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector
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	1								

Picklist Print

Wednesday, February 23, 2011 3:27:06 PM

Work Order ID: 66678

Parent Item:

D3201-1

Parent Item Name: Doubler

Start Date: 3/2/2011

Required Date: 3/4/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A

Removed from 9 Digit 06-01-25 JLM

IPP Rev:B

Now on Waterjet

06-08-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	192.2595	0.276	3.486316	6.17	<u>L</u>	
										Y	Q11-7-	29	

2024-T3 .040 sheet

Location	Loc Qty	Loc Code	
MAT	11.8		
114415	11.8		
MAT22	180.4595		
110305	21.93		
111786	7.66		
112291	22.45		119991
112331	52		
113162	76.4195		

Dart	Aeros	pace	Ltd
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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #:	Fault Categ	ory:	_ NCR: Yes	No DQ	A :	Date: _	.
	Res	olution:	Disposition	ı:	_ QA: N/C CI	osed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMA	ANCE (NCF	R)			
DATE	CTED	Description of NC			ion B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspecto
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l									

DART AEROSPACE LTD	Work Order:	66678
Description: Doubler	Part Number:	D3201-1
Inspection Dwg: D3201 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X Fire	st Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.50	+/-0.030	.50	×		RiGi	
3.57	+/-0.030	3,563	٧		V 1302	
R0.12	+/-0.030	12	8		R.G.	
8.00	+/-0.030	7.947	8		V	
0.58	+/-0.030	,575	6		V	
4.89	+/-0.030	4.885	Ve		V	
R0.25	+/-0.030	って	y		R.G.	
0.040	+/-0.010	PE0.	7		V	
		·				
				10-1-1-1-1-1		

Measured by:	1B	Audited by:	8	Prototype Approval:	N/A
Date:	11-2-39	Date:	11/02/24	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	03.11.28	New Issue	P/O D412-698-015	KJ/RF	

Dart Aerospace Ltd

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W/O:			W	ORK ORDER CHANG	ES				
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQ	A :	Date: _	
Resolution:		Dispositi	_ QA: N/C (QA: N/C Closed: Date:					
NCR:			WORK OR	DER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial Action Descri		ion B Sign Date			Approval Chief Eng	Approval QC Inspector
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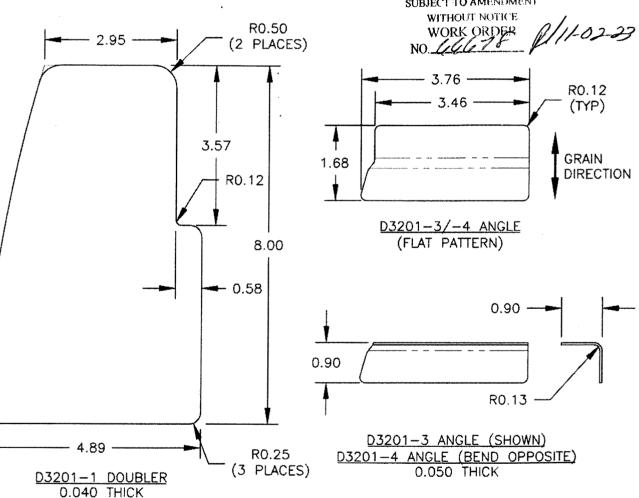
DESIG	"#	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	(ED A	APPROVED//	DRAWING NO. REV. B
	-#-	1	D3201 SHEET 1 OF 1
DATE	***************************************		TITLE SCALE
03.1	1.03		DOUBLER 1:2
Α		03.08.07	NEW ISSUE
В		03.11.03	MODIFY D3201-1, ADD D3201-3/-4

SHOP COPY

RETURN TO ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT



D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4) (REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:				· ·			QA: Date:		
Resolution:		esolution:	Disposition: Q			QA: N/C Closed: Date:			
NCR:			WORK ORI	DER NON-CONFORM	ANCE (NO	CR)			
DATE	STEP	STEP Description of NC Section A		tion B	veriti		cation Approval Approv		
DATE			Initial Chief Eng	Action Description Chief Eng	Sig ₁	า& _{Se}	ction C	Chief Eng	QC Inspector